

Work Order ID 86150

June-21-12 8:40:43 AM

86150

Page 1

Item ID: D2066

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2066

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

cut at 28.88

0.00

1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube
(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

SAD

12-11-07

4-Bend per Dwg D2066

5-Drill using DT9034

④

FF
12-11-12

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

121112

4

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

June-21-12 8:40:43 AM

86150

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Arm

Start Date: 21/06/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 05/07/2012 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

W 12-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-21-12 8:40:47 AM

Page 1

Work Order ID: 86150

86150

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP D 02.03.18 Added pick list NG

IPP E 07.10.03 removed p/c EC verified by: DD

IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	16			
AN960JD10													
Washer													
D2052		Manufactured	No			100	Each	16.0000	2	8			
D2052													
Mounting Bracket													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				GA	16								
				73052	3	B88361				5			
				83341	13					3			
D2054		Manufactured	No			100	Each	14.0000	2	8			
D2054													
Bushing													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				GA	14	B79836				6			
				79836	14	B87818				2			
D2055		Manufactured	No			100	Each	11.0000	1	4			
D2055													
Clamp													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				GA	11								
				77110	11					4			

m123248

**

16 SAA

12-11-06

**

SAA

12-11-06

**

SAA

12-11-06

**

SAA

12-11-06

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-21-12 8:40:47 AM

Page 2

Work Order ID: 86150

Parent Item: D2066

Parent Item Name: Arm

86150

D2066

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2056

Manufactured No

100

Each

3.0000

1

4

D2056

Bell Crank

**

S SAD

12-11-06

Location

Loc Qty

Loc Code

GA

3

71102

2

71889

1

MS21042L3

Purchased No

100

Each

3,654.000

85943

(4)

**

SAD

12-11-06

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

1654

117885

32

119017

816

119075

138

121444

668

ST317

2000

122141

2000

MS27039-1-18

Purchased No

100

Each

41.0000

1122452

8

**

SAD

12-11-06

MS27039-1-18

Screw

Location

Loc Qty

Loc Code

ST291

41

115589

1

120308

15

121556

25

1123522

(8)

June-21-12 8:40:48 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-21-12 8:40:48 AM

Page 3

Work Order ID: 86150

Parent Item: D2066

Parent Item Name: Arm

86150

D2066

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

M304TR0.500W.049

Purchased

No

120

f

186.4011

2.386

10.04632

M304TR0 500W 049

304 RD Tube .500 x .049W

**

SAD

12-11-07

Location

Loc Qty

Loc Code

MAT017

186.40111

111814

2.23

115010

109.254058

117598

1.47

119087

7.359

120633

66.088052

10.0469

June-21-12 8:40:48 AM

Shop Packet Print

Page 3

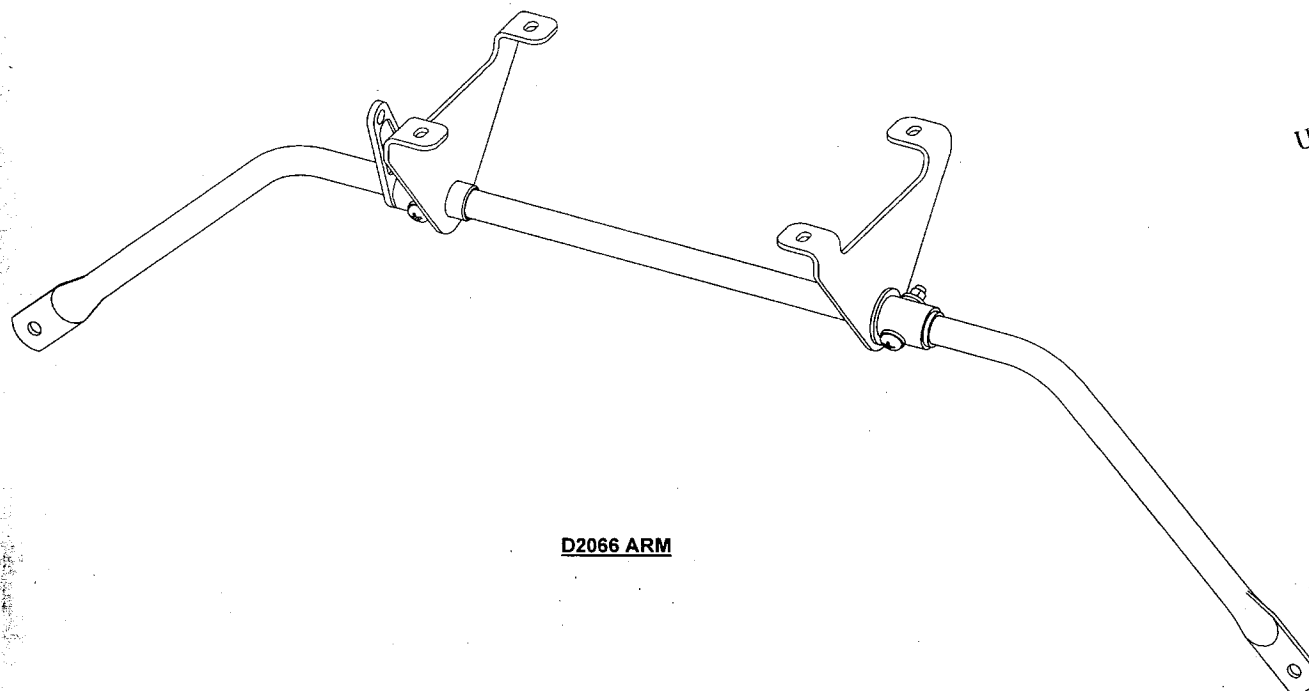
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2066 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86150-1165
12/06/21

RELEASED
08-07-25-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS: ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	FL		
CHECKED	FL	DRAWING NO.	REV. C
MFG. APPR.	FL	D2066	SHEET 1 OF 2
APPROVED	FL	TITLE	SCALE
DE APPR.	FL	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

26150



D2066-1 ARM BENDING DETAIL 

Technical drawing of a punch assembly. The drawing shows a long cylindrical shaft with various components and dimensions. Key dimensions include a total length of 28.63, a diameter of $\phi 0.257$ at the left end, and a diameter of $\phi 0.500$ in the middle section. The shaft is supported by a D2056 BELL CRANK and a D2052 BRACKET. A D2054 BUSHING and a D2055 CLAMP are also shown. The shaft is labeled D2066-1F ARM. The drawing includes a reference dimension of 0.049 REF and a reference dimension of 0.40 2 PL. REF. The shaft is labeled PUNCH PER D2727 2 PL. REF.

D2066-1F ARM CUT LENGTH DETAIL 

9) DRILL $\phi 0.188$ AFTER BENDING

RELEASED
08-07-23

COPYRIGHT © 1996 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries